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D3914-041
Job Sheet 183330



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pcl DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Large Fab-5		DC 2018-09-25
100	Large Fab	1 pcs	10/19/18	10/19/18	0.00	6.67	Large Fab 1		DC 2018-09-25
110	QC	1 pcs	10/19/18	10/19/18	0.00	0.00	QC9		MS
120	QC	1 pcs	10/19/18	10/19/18	0.00	0.00	QC5		MS
130	Powdercoat	1 pcs	10/19/18	10/19/18	0.00	0.40	Powdercoat4		BFB 18-10-18
135	QC	1 pcs	10/19/18	10/19/18	0.00	0.00	QC3		MS 18-10-19
140	HandFinish	1 pcs	10/19/18	10/19/18	0.00	0.80	HandFinish3		MS 18-10-19
150	QC	1 pcs	10/19/18	10/19/18	0.00	0.00	QC3		MS 18-10-19
160	Packaging	1 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-2		OCT 19 2018
170	QC21-SA	1 Ea	10/19/18	10/19/18	0.00	0.00	QC21		OCT 19 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138839 START: 3:25 TEMP: 320° FINISH: 3:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097822
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5098715 / 5112316
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5108958
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5109117
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5110523
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5111008
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5064261
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5108405

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

90-Start up Operation

D2581	2	92	0
D3914-1	2	11	0
D3914-7	2	16	0
D4016-3	3	22	0
D4018-5	9	57	0
D4020-5	1	2	0
D4021-3	1	14	0
D4035-043	2	14	0

Part Specifications

Specifications could not be found.

Plex 9/17/18 7:41 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NO

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____ Step #: _____

Description Work Order Deviation

DART
 AEROSPACE
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 Hamilton, ON K8A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartero.com
 www.dartero.com
 Part: D3914-041
 Job No: 183330
 Serial No/Batch: S113298
 Revision: A/D
 Inspector:
 Exp Date:
 Instructions: Various STC's
 Date: 09/25/18

QC / QA Coordinator
Approval

Root Cause				FAULT CATEGORY						
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							